

# Work Order ID 47824A

June 26, 2009 8:15:26 AM



Page 1

Item ID: D3326-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Basket Base Assembly

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3326

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D33261 QtyPart Number Description  
Batch: 12D3328-3 Hinge Plate M109129 14D3348-1  
Clevis M109129 12D3349-3 Spacer Bushing  
M109129 2D3367-1 Mounting Bracket M109129 Idem

SAD 09-07-14 Cpl 09-07-20

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09-07-20

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 02/11/21

SCD P

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Page 2

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

0.00

1ST COAT: START TIME:

9:30

OVEN TEMPERATURE:

FINISH TIME:

10:00

\*\*\*\*\*

2nd coat if necessary\*\*\*\*\* 2ND COAT: START

TIME:

OVEN TEMPERATURE:

Pl 09-07-22 ①

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

M-h 09/07/22 ①X

150

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

PP 47824

9/1/24 ① Sg

# Work Order ID 47824A

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Page 3

Item ID: D3326-041  
Revision ID: B  
Item Name: Basket Base Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 1.00



Required Date: 03/08/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/27

u 9.07.27

# Picklist Print

June 26, 2009 8:15:26 AM

Page 1

Work Order ID: 47824A

Parent Item: D3326-041 RevB

Parent Item Name: Basket Base Assembly



Comments:

Start Date: 15/07/2009


Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4130NTS0.500W.035		Purchased	No			100	f	0.0000	32.3684			
												
4130 Square tube .500 x .500 x .035w												
M569EX0.50-18F		Purchased	No			100	sf	0.0000	28.0000			
												
569 Expanded Metal												

M109127 <sup>Qty</sup> 1.5 End Bar Scrap

 M109127 SADO9-07-15

 M109289 PLO9-07-16

Qty	PART #	DESCRIPTION	BATCH	
2	D3328-3	HINGE PLATE	B33872	PLC
4	D3348-1	CLIPS	B41830	PLC
2	D3349-3	SPACER BUSHING	B41831	PLC
2	D3367-1	MOUNTING BRACKET	B43228	PLC

Boms  
updated by  
DANN Duvall



parts NOT scanned

Date: Friday, 08/05/2009 1:04:19 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY
Job Number	: 47824A		
Estimate Number	: 11331		
P.O. Number	:	Part Number	: D3326041
This Issue	: 08/05/2009 S.O. No. :	Drawing Number	: D3326 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 32863A	Material	:
Written By	:	Due Date	: 15/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-05-08</u>		
Comment	: Est A05.02.09 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	✓ M4130NTS0500W035	4130 Square tube .500 x .500 x .035w
-----	--------------------	--------------------------------------



Comment: Qty.: 32.2875 f(s)/Unit Total : 32.2875 f(s)  
 Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall  
 (M4130N-TS0.500W.035)  
 Identify parts appropriately

SAN 09-07-04

2.0	✓ M569EX05018F	569 Expanded Metal
-----	----------------	--------------------



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)  
 Pick:  
 Qty Part Number Description Batch  
 28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel M107289

09-07-16

3.0	✓ LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	---------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1  
 1-Cut tubes as per Dwg D3326

Qty	Part Number	Description	Batch
2	D3328-3	Hinge Plate	<u>B33872</u>
4	D3348-1	Clevis	<u>B41830</u>
2	D3349-3	Spacer Bushing	<u>B41831</u>
2	D3367-1	Mounting Bracket	<u>B43228</u>

Identify parts appropriately

2-Remove all markings from material and deburr as required check for foreign objects.

3-Drill and Weld as per Dwg D3324 & QSI 004  
 A/RN/A Steel Rod M100075

09-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 08/05/2009 1:04:19 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 47824A

Part Number: D3326041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr as required

4.0



QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-20

5.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09-07-21 @

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 11/2/48.

1ST COAT:

START TIME:

9:30

OVEN TEMPERATURE:

400°

FINISH TIME:

10:00

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

BR 09-07-22 (D)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h 09/07/22 (IX)

8.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

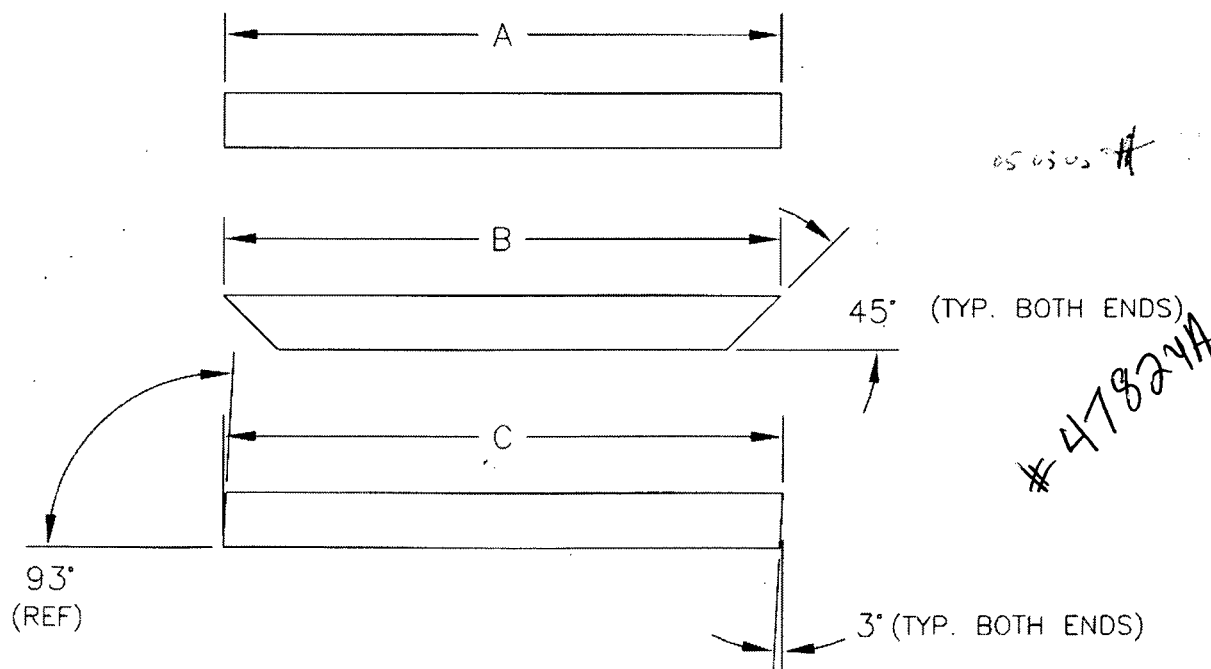




DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3326	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.21	NEW ISSUE	
B	05.03.04	UPDATE TUBING AND MESH MAT'L SPEC	

PARTS LIST FOR D3326-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3326-1	1	14.00	N/A	N/A	BOTTOM TUBE
D3326-3	4	N/A	56.50	N/A	FULL LENGTH TUBE
D3326-5	2	N/A	16.00	N/A	TOP END TUBE
D3326-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3326-9	6	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



D3326-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL  
(REF. DART SPEC M4130-TS0.500W.035)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

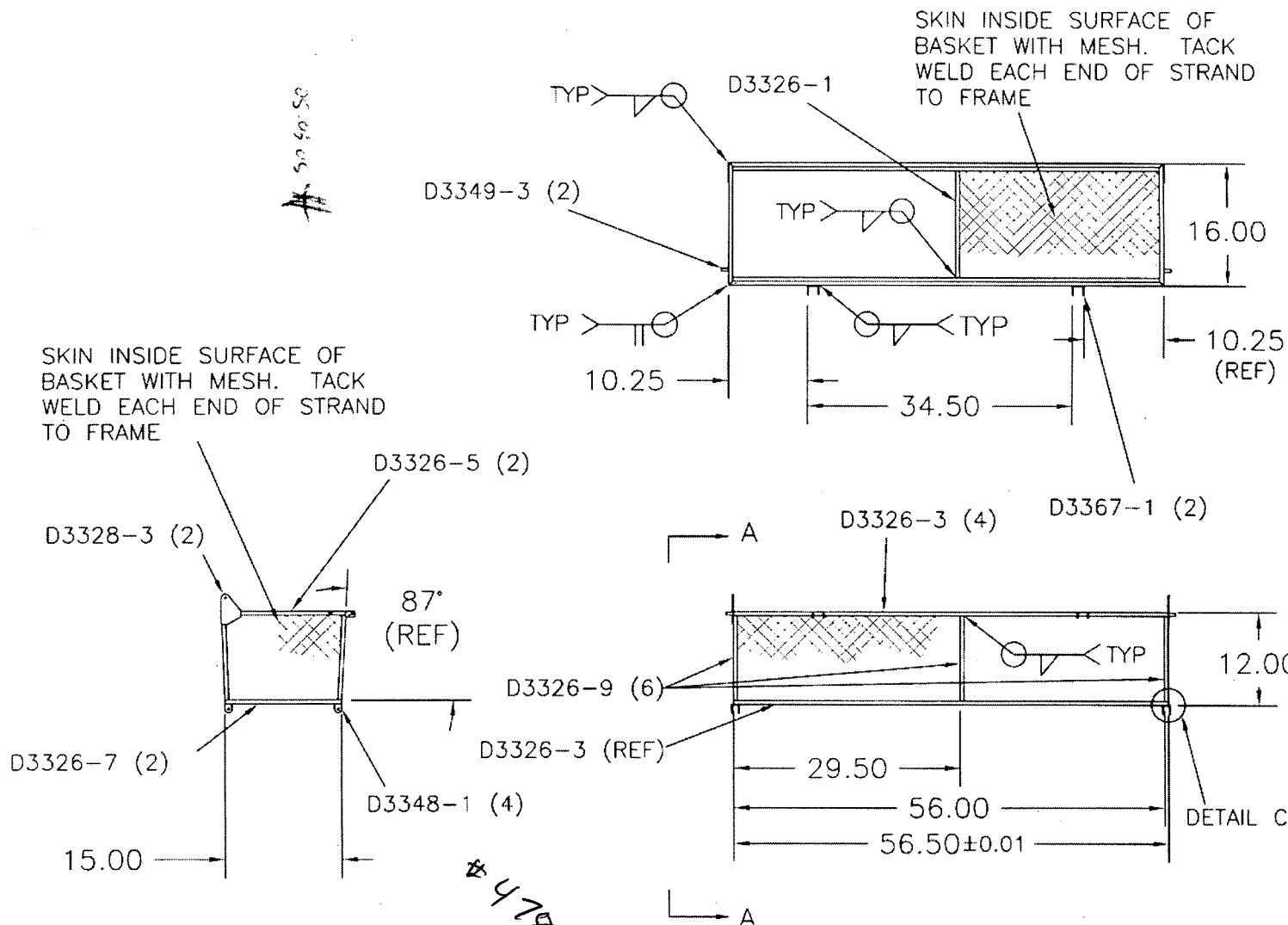
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
05.03.04	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE 1:25



# D3326-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18 GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

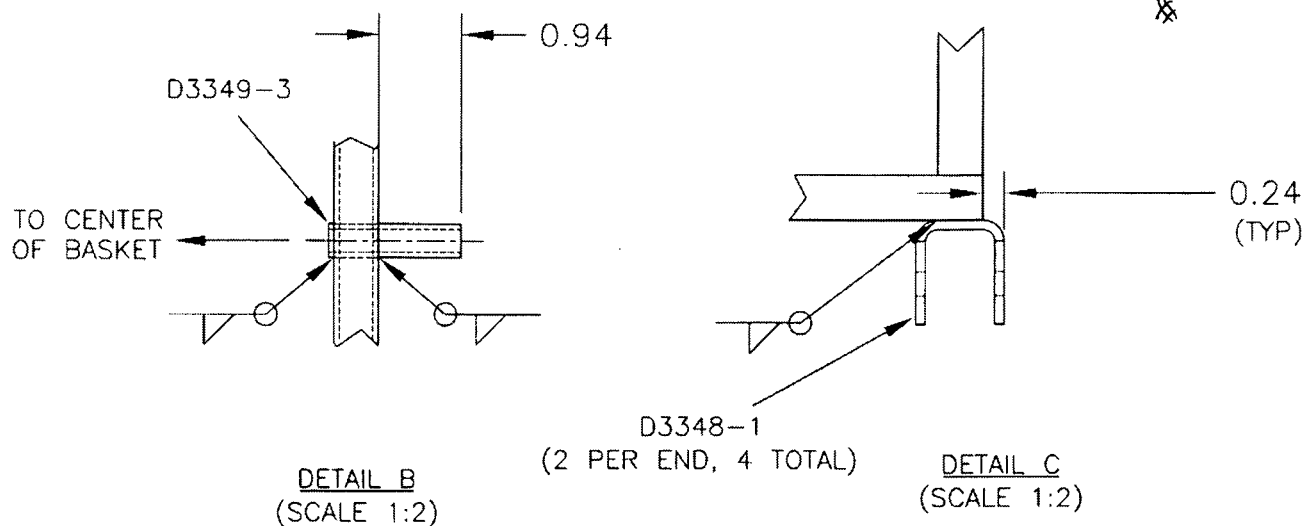
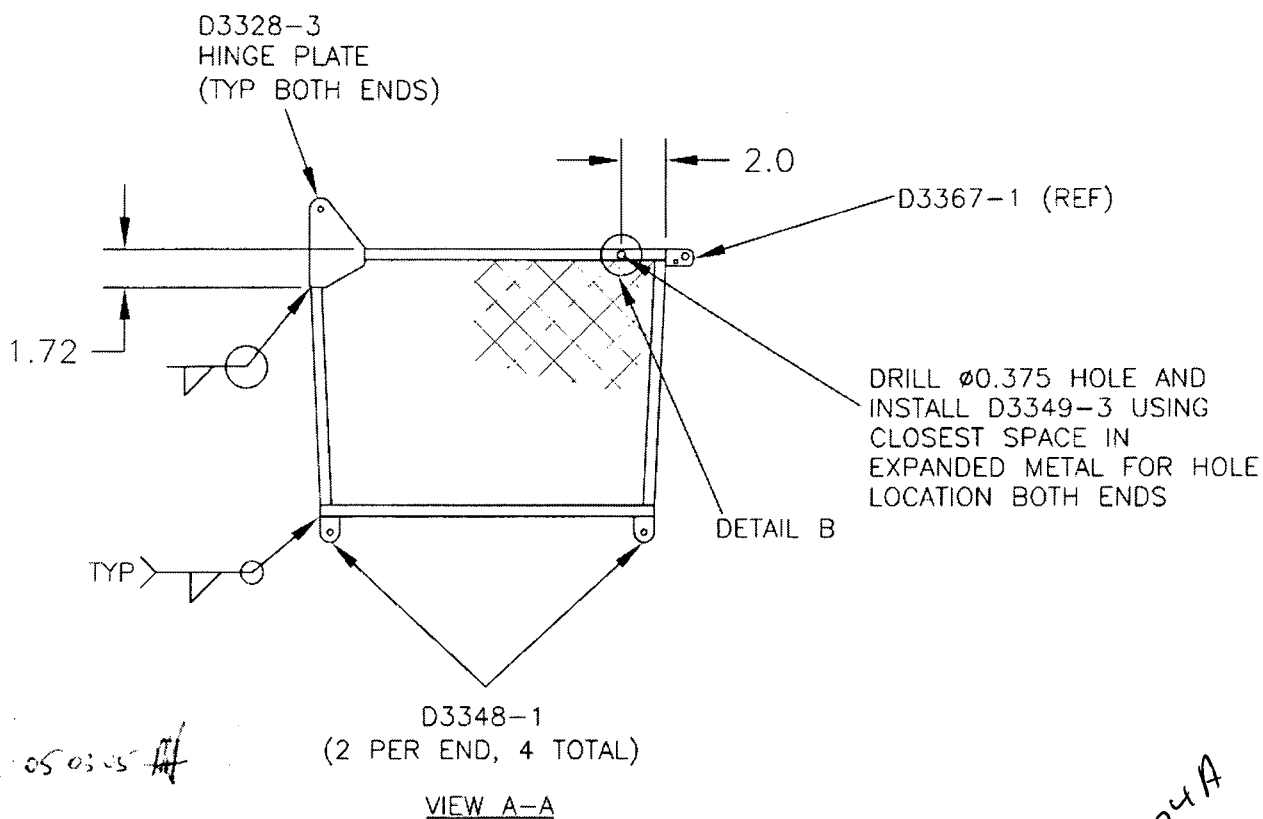
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3326	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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